

Date: Tuesday, 30/09/2008 11:14:20 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
Job Number :	42360	Part Number :	D2572	
Estimate Number :	10531	Drawing Number :	D2572 REV E	
P.O. Number :		Project Number :	N/A	
This Issue :	30/09/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	E	
First Issue :	11	Material :		
Previous Run :	41704	Due Date :	17/10/2008	Qty: 17 Um: Each
Written By :				
Checked & Approved By :	<u>JUL 08.9.20</u>			
Comment :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: B34874

mk 08/10/22

(17)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 42360 Double check by: B.A

(Ph)

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

mk/SL 08/10/28

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

SL 08/10/28

[illegible]

Date: Tuesday, 30/09/2008 11:14:20 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 42360

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 8/10/28

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 28/10/28

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/10/28

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320°F
11:00

M-L

08/10/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FZ 08/10/30

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

SA 8/10/30

MX

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/03

Job Completion



VL 08.10.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42360	
Description: Saddle, Fwd Inboard		Part Number: D2572	
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.500	.501	.501		
G	0.257	0.262		.259	.259	.258	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.501	.501		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.566	.567		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.492	1.493	1.495	1.494		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	3.869	3.879		3.869	3.872	3.874	3.874		
P	0.115	0.135		.124	.123	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.129	.126	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.238	.240	.240	.235		
W	0.115	0.135		.126	.129	.129	.126		
X	0.307	0.312		.311	.312	.311	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.358	.362	.359	.356		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.626	.626	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.222	.250	.249	.246		
AE	1.375	1.395		1.388	1.386	1.391	1.391		
AF	0.115	0.135		.130	.130	.130	.135		
AG	0.240	0.280		.278	.260	.260	.260		
AH	0.240	0.260		.248	.251	.249	.248		
AI	2.000	2.020		2.003	2.001	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>ML / SL</i>
Date: 08/10/27 / 08/10/23

Audited by: <i>SS</i>
Date: 08/10/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 42360
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	18	26	37	48	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.001		
F	0.490	0.510		.500	.500	.500	.503		
G	0.257	0.262		.260	.259	.260	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.490	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.558	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.493	1.494	1.495		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.871	3.871		
P	0.115	0.135		.128	.128	.129	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.251	.252		
S	0.115	0.135		.129	.130	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.960	2.960		
V	0.230	0.250		.236	.236	.239	.236		
W	0.115	0.135		.128	.130	.130	.127		
X	0.307	0.312		.308	.308	.308	.308		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.365	.364	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.246	.249	.246		
AE	1.375	1.395		1.391	1.389	1.390	1.391		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.253	.250	.250		
AH	0.240	0.260		.248	.250	.250	.250		
AI	2.000	2.020		2.005	2.004	2.006	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>mf</i>
Date: 08/10/27

Audited by: <i>SP</i>
Date: 08/30/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>mf</i>

DART AEROSPACE LTD	Work Order: 42360
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/8"	2/10"	3/16"	1/2"	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	7.999	7.999		
F	0.490	0.510		.502	.502	.501	.501		
G	0.257	0.262		.260	.259	.260	.260		
H	0.375	0.380		.377	.377	.378	.377		
I	0.490	0.510		.503	.503	.498	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.561	.571		
L	1.174	1.184		1.179	1.179	1.178	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.494		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.872	3.871	3.872		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.120	.130	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.959	2.960		
V	0.230	0.250		.240	.239	.240	.240		
W	0.115	0.135		.122	.125	.129	.130		
X	0.307	0.312		.316	.310	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.357	.355	.363	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.242	.244	.245	.247		
AE	1.375	1.395		1.391	1.392	1.389	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.255	.258	.256		
AH	0.240	0.260		.250	.249	.250	.250		
AI	2.000	2.020		2.004	2.006	2.003	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	mp
Date:	08/10/27

Audited by:	SB
Date:	08/10/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

3-20
057
0.1

DART AEROSPACE LTD	Work Order: 42360
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#13	#14	#15	#16	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.998	7.998		
F	0.490	0.510		.499	.502	.503	.499		
G	0.257	0.262		.260	.260	.260	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.504	.502	.502	.504		
J	1.174	1.184		1.179	1.179	1.178	1.179		
K	0.558	0.578		.574	.571	.571	.571		
L	1.174	1.184		1.179	1.179	1.178	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.494		
N	2.495	2.505		2.499	2.499	2.500	2.499		
O	3.869	3.879		3.871	3.872	3.872	3.872		
P	0.115	0.135		.132	.130	.131	.131		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.254	.254	.255		
S	0.115	0.135		.132	.134	.134	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.957	2.958		
V	0.230	0.250		.241	.240	.240	.240		
W	0.115	0.135		.130	.130	.131	.132		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.364	.364	.365		
AA	0.470	0.530		.500	.500	.500	.506		
AB	0.615	0.635		.629	.629	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.244	.245	.247		
AE	1.375	1.395		1.391	1.390	1.390	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.255	.252	.255	.260		
AH	0.240	0.260		.250	.250	.251	.251		
AI	2.000	2.020		2.005	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>MR</i>
Date: 08/10/27

Audited by: <i>88</i>
Date: 08/10/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

42360

DART AEROSPACE LTD	Work Order: <u>42503</u>
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	7	3i	4		
A	0.438	0.443		.440					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.000					
F	0.490	0.510		.501					
G	0.257	0.262		.260					
H	0.375	0.380		.377					
I	0.490	0.510		.503					
J	1.174	1.184		1.179					
K	0.558	0.578		.571					
L	1.174	1.184		1.179					
M	1.490	1.500		1.495					
N	2.495	2.505		2.499					
O	3.869	3.879		3.872					
P	0.115	0.135		.131					
Q	0.115	0.135		.135					
R	0.240	0.260		.254					
S	0.115	0.135		.132					
T	0.178	0.198		.188					
U	2.940	2.980		2.958					
V	0.230	0.250		.240					
W	0.115	0.135		.127					
X	0.307	0.312		.309					
Y	0.760	0.765		.760					
Z	0.352	0.372		.363					
AA	0.470	0.530		.500					
AB	0.615	0.635		.625					
AC	0.053	0.073		.063					
AD	0.240	0.260		.248					
AE	1.375	1.395		1.390					
AF	0.115	0.135		.135					
AG	0.240	0.280		.258					
AH	0.240	0.260		.250					
AI	2.000	2.020		2.006					
AJ	0.023	0.043		.033					
Accept/Reject									

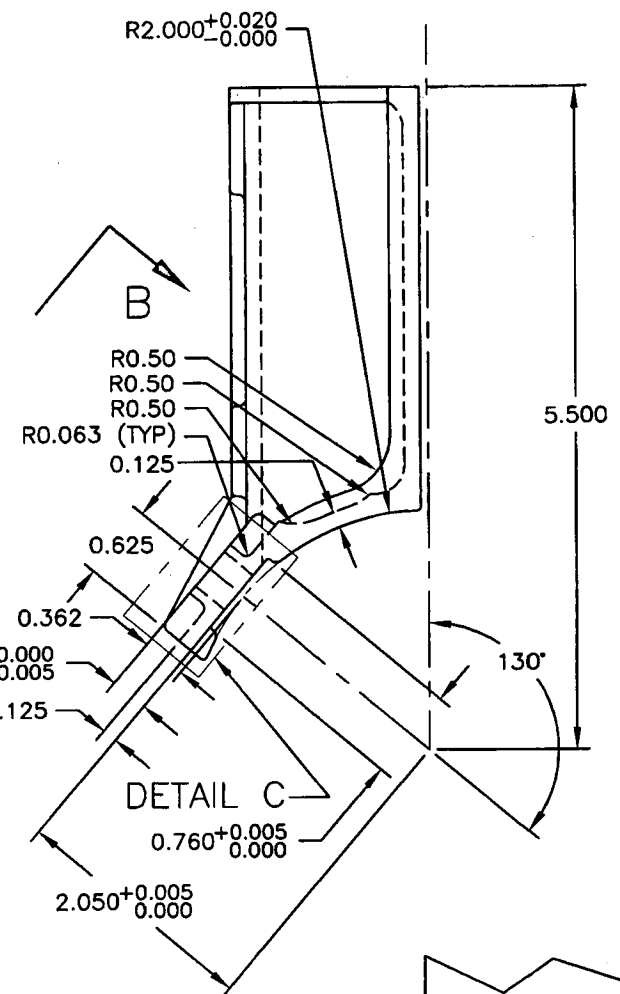
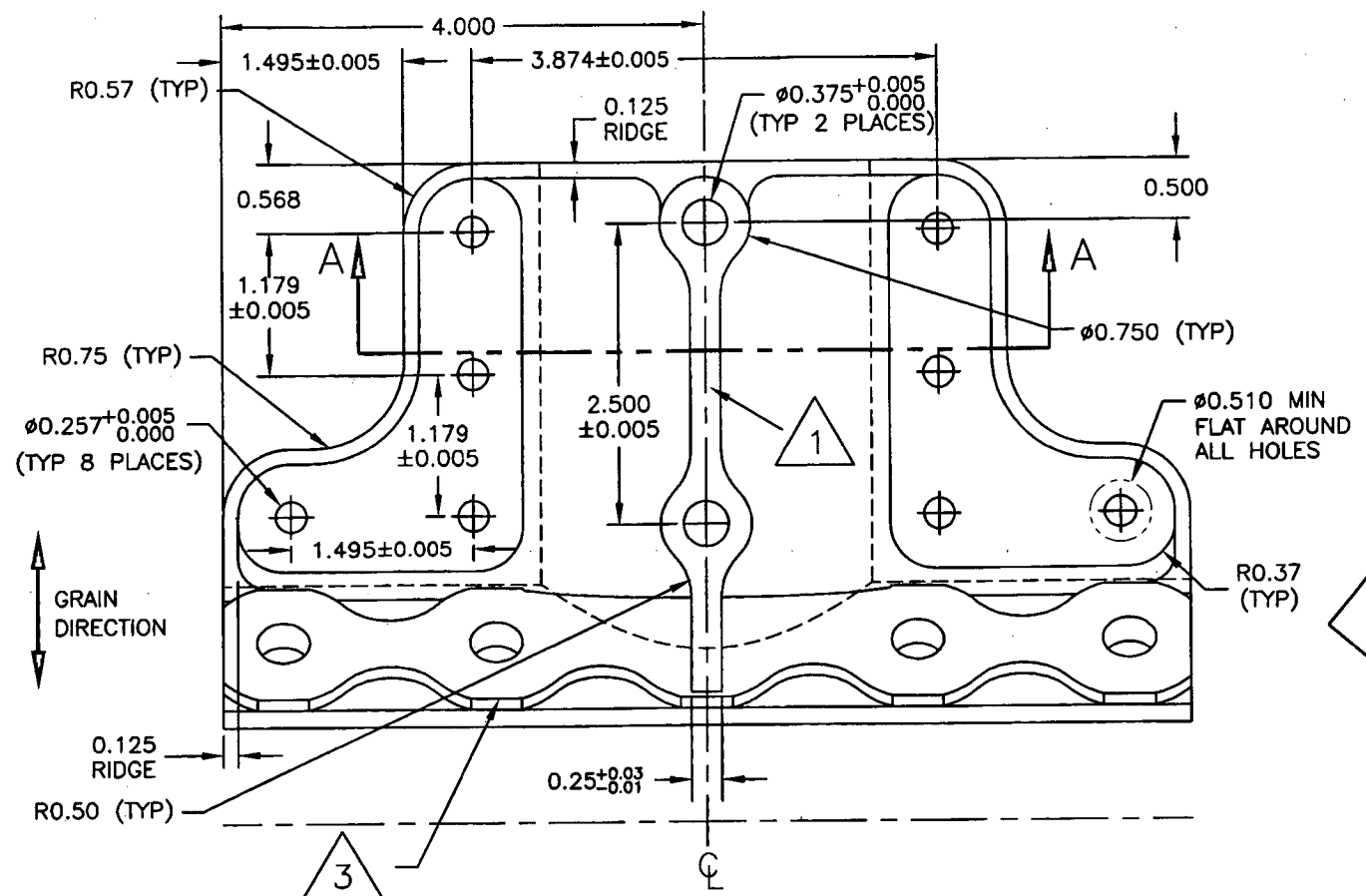
Measured by: <u>cmk</u>
Date: <u>08/10/27</u>

Audited by: <u>SB</u>
Date: <u>08/10/28</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

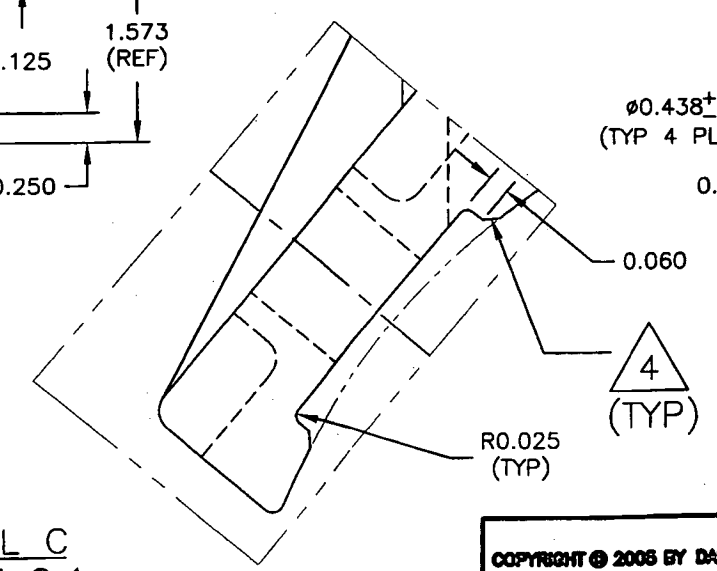
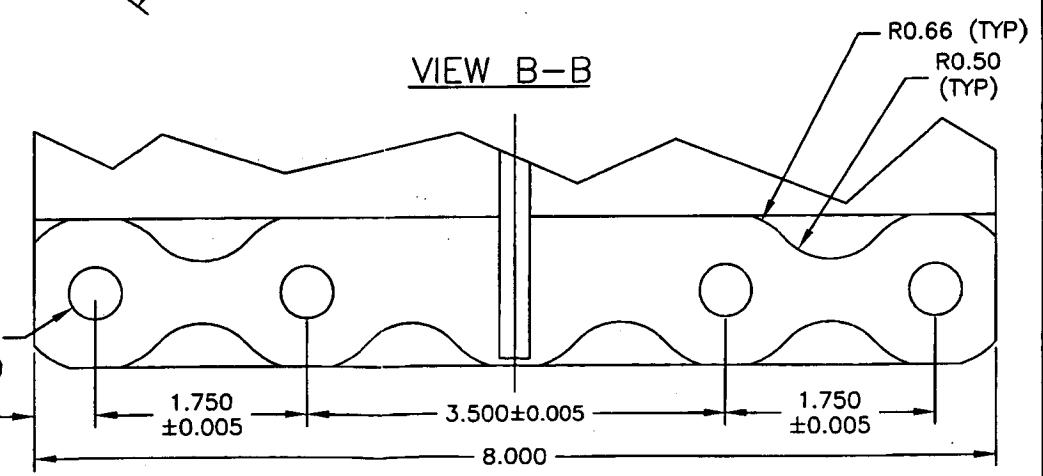
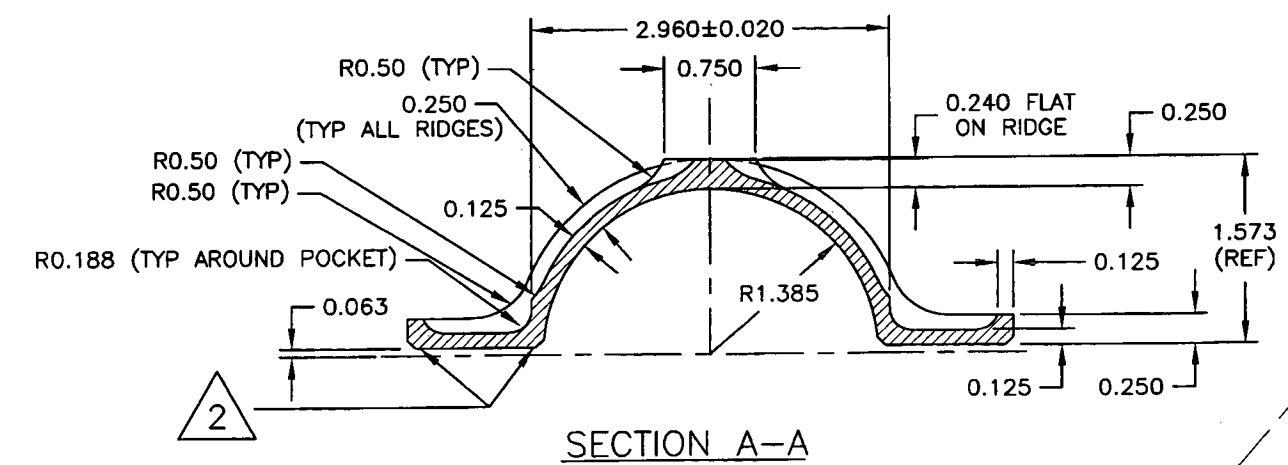
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	
DATE 05.07.13	DRAWING NO. D2572	TITLE INNER FWD SADDLE

NO. 42300

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 23, 2008 1:56 PM
To: 'Chris Provencal'
Subject: RE: Emailing: NCR-D2571.jpg

Agree. Parts are acceptable.

David

-----Original Message-----

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, October 23, 2008 8:40 AM
To: 'David Shepherd'
Subject: Emailing: NCR-D2571.jpg

David,

D2751 & D2752, both and inner and outer saddle have the top ridge 0.220" (nominal = 0.250") under tolerance, see attached picture. I don't have anything to substantiate this by calculation. However, on the basis that the original saddle did not have this ridge, I would conclude that these saddles are acceptable. Do you concur?

-Chris

No virus found in this incoming message.
Checked by AVG.

Version: 7.5.549 / Virus Database: 270.8.2/1739 - Release Date: 10/22/2008
7:23 AM

No virus found in this outgoing message.
Checked by AVG.

Version: 7.5.549 / Virus Database: 270.8.2 - Release Date: 10/20/2008 12:00 AM

